

DEPARTMENT OF TRANSPORTATION**DIVISION OF ENGINEERING SERVICES**

Office of Structural Materials

Quality Assurance and Source Inspection



Bay Area Branch

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Contract #: 04-0120F4Cty: SF/ALA Rte: 80 PM: 13.9/14.3,0.0/1.6File #: 69.28**WELDING INSPECTION REPORT****Resident Engineer:**Pursell, Gary**Address:** 333 Burma Road**City:** Oakland, CA 94607**Report No:** WIR-000830**Date Inspected:** 08-Nov-2007**Project Name:** SAS Superstructure**OSM Arrival Time:** 630**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 1530**Contractor:** Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island **Location:** Shanghai,China**CWI Name:** Cin Yi Ru**CWI Present:** Yes No**Inspected CWI report:** Yes No N/A**Rod Oven in Use:** Yes No N/A**Electrode to specification:** Yes No N/A**Weld Procedures Followed:** Yes No N/A**Qualified Welders:** Yes No N/A**Verified Joint Fit-up:** Yes No N/A**Approved Drawings:** Yes No N/A**Approved WPS:** Yes No N/A**Delayed / Cancelled:** Yes No N/A**Bridge No:** 34-0006**Component:** 114 skin plate**Summary of Items Observed:**

Caltrans Quality Assurance (QA) Inspector Tim McClendon arrived on site at the Zhenhua Port Machinery Company (ZPMC) facility at Changxing Island, in Shanghai, China to periodically monitor welding and Quality Control (QC) functions. While on site the QA Inspector observed and/or discovered the following.

The QA Inspector randomly observed ZPMC welder Chang Chuan cang ID Number 053870, utilizing the Flux Cord Arc Welding (FCAW) Process to perform weld repair on 114m Mock up, with approved ZPMC WPS WPS-345-FCAW-2G(2F)-Repair, to weld the fill passes to weld #7 in the 1G position in an excavation on WJ MUSC-MA112, , attaching longitudinal stiffener piece mark mp1005 to 112 Skin Plate C, Sub-Assembly MUSC-MA112. The QA Inspector observed ZPMC CWI Cin Yi Ru monitoring weld parameters. The QA Inspector also performed random verification of the weld parameters and documented them as follows: welding amperage 299 amps, welding voltage 29 volts with a travel speed of 310 millimeters per minute. Weld parameters appeared to comply with the above approved ZPMC WPS.

Summary of Conversations:

Within body of report.

Comments

This report is for the purpose of determining conformance with the contract documents and is not for the purpose of making repair or fit for purpose recommendations. Should you require recommendations concerning repairs or remedial efforts please contact Mazen Wahbeh, (818) 292-0659, who represents the Office of Structural Materials for your project.

WELDING INSPECTION REPORT

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Inspected By:	McClendon, Timothy	Quality Assurance Inspector
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Reviewed By:	Cuellar, Robert	QA Reviewer
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